

77738

Tuesday, December 20, 2011 7:55:12 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/20/2011 **Start Qty:** 6.00

6

Cust Item ID:

Required Date: 12/20/2011 **Req'd Qty:** 6.00

6

Customer:

Reference:

Run Start *NR1*

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3195	Rev A

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: (0.75" x 2.00") x 3.60" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine D3195-1 as per Folio FA334 and Dwg D3195 Identify as D3195-1 Debur

120

0.00

120

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

Page 2

2-15

Work Order ID 77738

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Page 3

Tuesday, December 20, 2011 7:55:12 AM

Item ID: D3195-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket Assembly
 Start Date: 12/20/2011 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 12/20/2011 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160						6	BL	11-12-21.	
QC	Memo	0.00							
Quality Control									
170		0.00							
170	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1-Lightly Sand bonding surface2-Bond D3195-5 into D3195-1 as per Dwg D3195A/RContact Cement								
	OR SM 1300/1300L								
	M119597								
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							
Quality Control									

[Handwritten signature] 11/12/22 (6)

[Handwritten signature]

77738

Tuesday, December 20, 2011 7:55:12 AM

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 12/20/2011 **Start Qty:** 6.00 ***6***

Cust Item ID:

Required Date: 12/20/2011 **Req'd Qty:** 6.00 ***6***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

Identify as per dwg & Stock Location: 246A

0.00

190

Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00


200

QC

Memo

0.00

Quality Control

11/2/22 

MF
11-12-22

Picklist Print

Tuesday, December 20, 2011 7:55:11 AM

Page 1

Work Order ID: 77738

Parent Item: D3195-041

Parent Item Name: Bracket Assembly

Start Date: 12/20/2011

Required Date: 12/20/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A New Issue 05-11-08 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3195-5 Pad		Manufactured	No			100	Each	8.0000	1	6		12/12/22	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		8							
				75065		2							
				77081		6							
M6061T6B0.750X02.000 6061-T6 Bar .750 x 2.00		Purchased	No			170	f	26.2850	0.3	1.8947368			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				MAT002		26.285							
				100742		3.271							
				→ 111448		11.014							
				119653		12							
									1.9			12/12/20	

DART AEROSPACE LTD		Work Order:	77738
Description: Bracket		Part Number:	D3195-1
Inspection Dwg: D3195 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.265	+/-0.010	1.262	✓		FK-04	Vern.
0.242	+/-0.010	.244	✓		"	"
1.084	+/-0.010	1.086	✓		31006	Height gauge
R0.200	+/-0.010	.200	✓		rad gauge	
R0.377	+/-0.010	.377	✓		" "	
Ø0.277	+0.005/-0.000	.277	✓		FK-04	Vern.
2.677	+/-0.005	2.677	✓		"	"
3.432	+/-0.010	3.432	✓		"	"
0.754	+/-0.010	.754	✓		"	"
1.387	+/-0.010	1.387	✓		"	"
0.500	+/-0.010	.500	✓		"	"
0.250	+/-0.005	.250	✓		"	"
1.754	+/-0.010	1.754	✓		"	"
Ø0.191	+0.005/-0.000	.191	✓		"	"

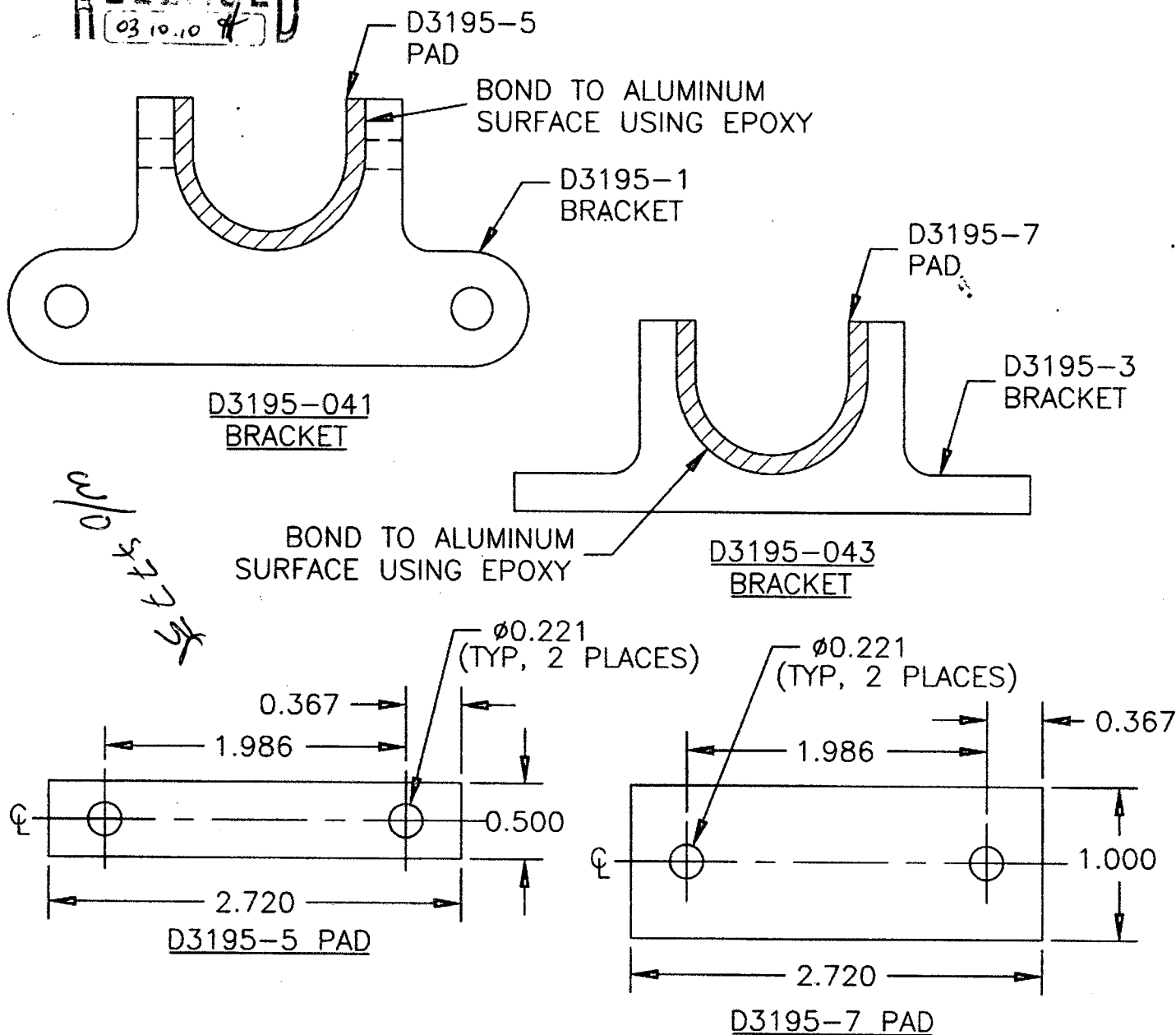
Measured by:	FK	Audited by:	SL	Prototype Approval:	N/A
Date:	11/12/21	Date:	11-12-21	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D412-702-011/-13)	KJ/RF	JK



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3195	REV. A SHEET 1 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1
A	03.06.23	NEW ISSUE	

RELEASED
03.10.10



D3195-5 & D3195-7 PAD

- 1) MATERIAL: 60 DUROMETER NEOPRENE 1/8" THICK
(POSSIBLE SUPPLIERS, ACCURATE RUBBER)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 3) ALL DIMENSIONS ARE IN INCHES

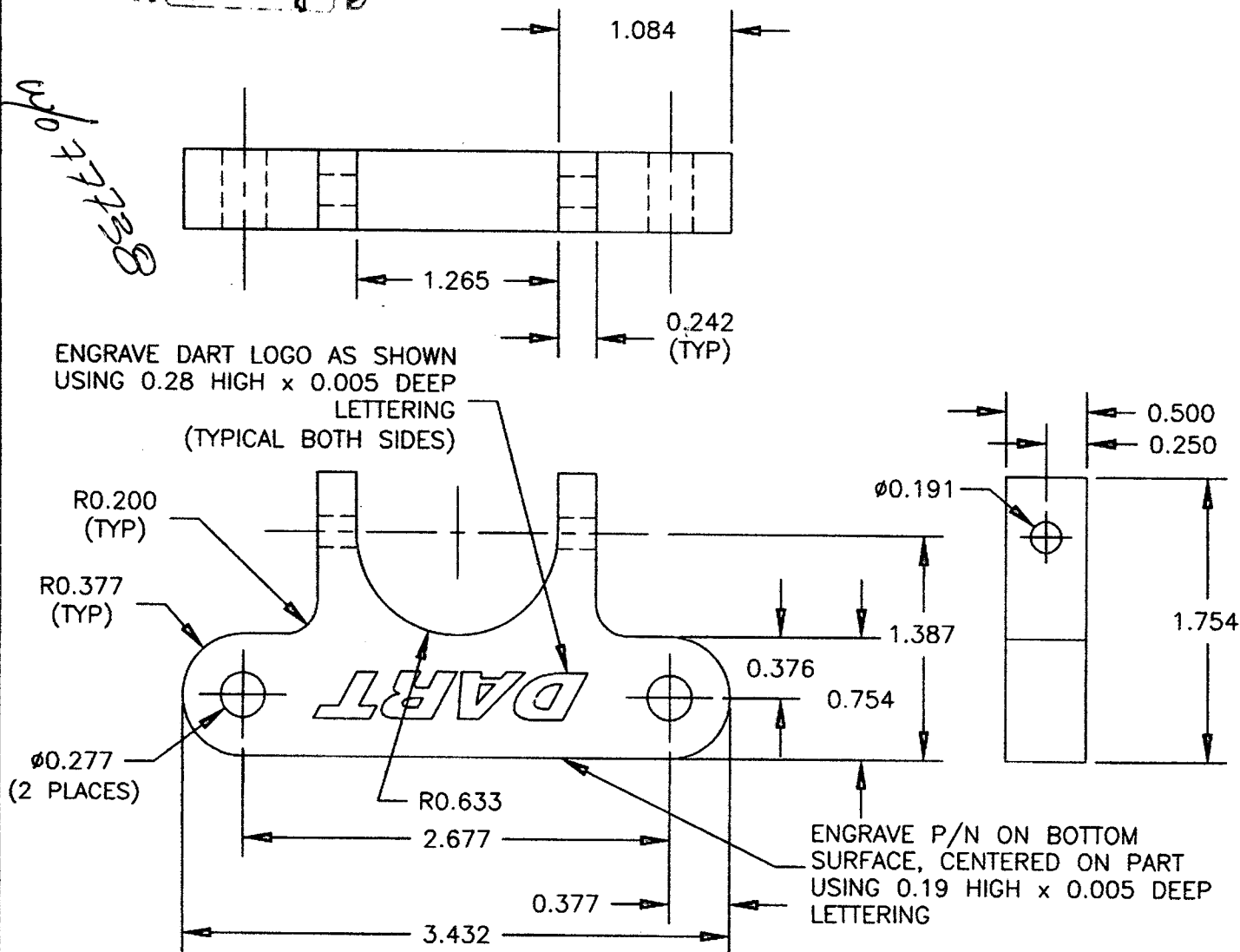
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3195	REV. A SHEET 2 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1

RELEASED
03.10.10



D3195-1 BRACKET

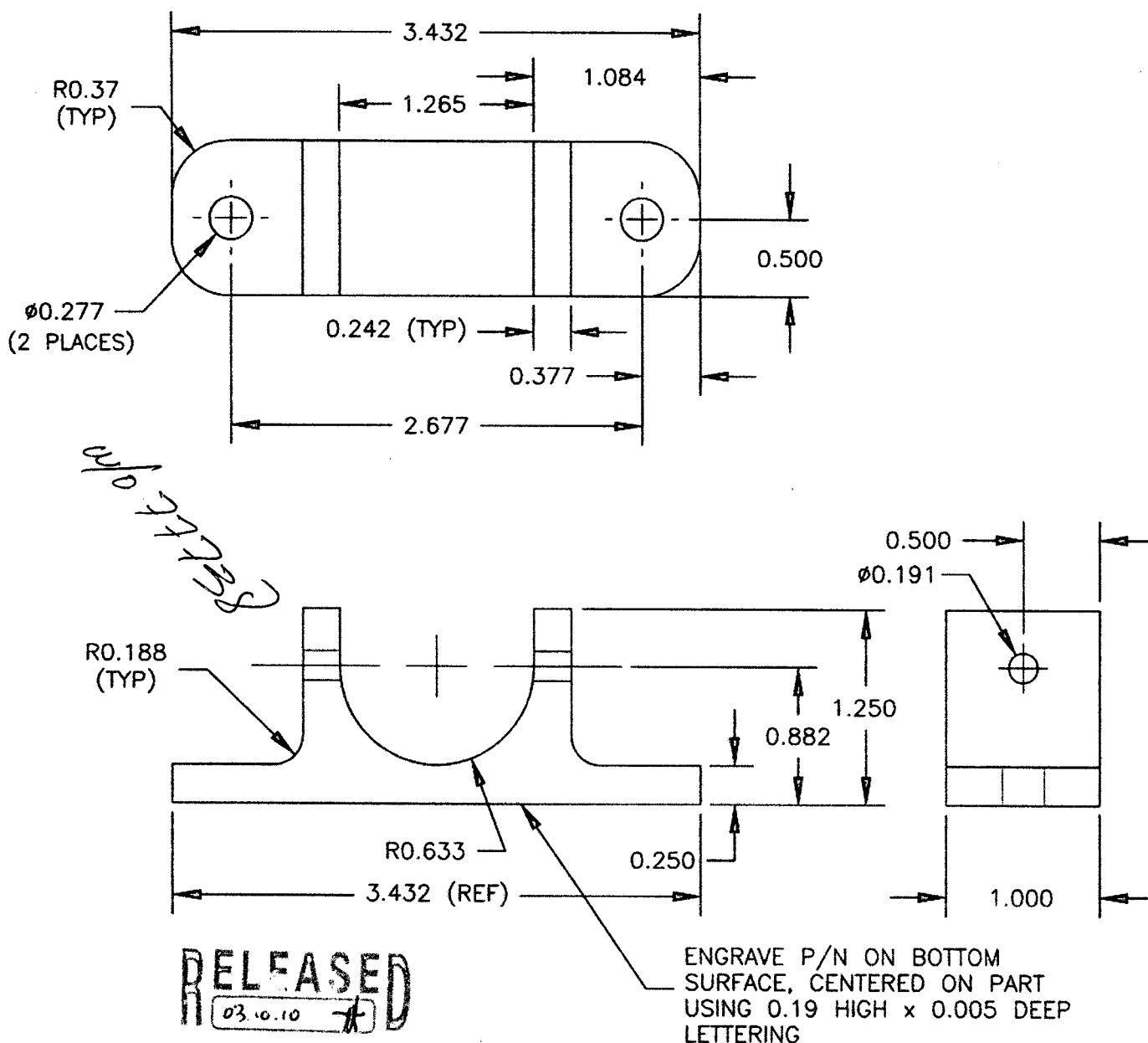
- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3195	REV. A SHEET 3 OF 3
DATE 03.06.23		TITLE BRACKET	SCALE 1:1



D3195-3 BRACKET

- 1) MATERIAL: 6061-T6/T651 (QQ-A-250/11 OR QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC M6061T6S OR M6061T6B)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 3) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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